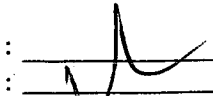
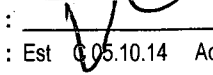


Date: Friday, 03/11/2006 7:48:20 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR PANEL
Job Number : 29243	
Estimate Number : 11401	
P.O. Number : <i>N/A</i>	Part Number : D32961
This Issue : 03/11/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3296 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 29243	Material : <i>A/A</i>
Written By : 	Due Date : 24/11/2006 Qty: 8 Um: Each
Checked & Approved By : 	
Comment : Est 05.10.14 Added step 14 KJ/EC Est Rev:D Now on Waterjet 06-11-02 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 0.6926 sf(s)/Unit Total : 5.5406 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063)
 Identify for D3296-1
 Batch: *M10022 ml 06 11 09*

(8)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3296
 Dwg Rev: *A*
 Prog Rev: *A*

ml 06 11 09

(8)

2-Deburr if necessary

SAD 06:11:12

(8)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE*ml 06 11 09*

(8)

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK*ml 06/11/09*

(8)

Date: Friday, 03/11/2006 7:48:20 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR PANEL

Job Number: 29243

Part Number: D32961

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

SAD 06/11/12

8

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

mlog/11/17

8

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/11/17

8

8.0

D31617

Hinge 14"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
Hinge 14"

Pick:

Qty	Part Number	Description	Batch
1	D3161-7	Hinge	

9.0

D31619

Hinge 17"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
Hinge 17"

Pick:

Qty	Part Number	Description	Batch
1	D3161-9	Hinge	

10.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 24.0000 Each(s)/Unit Total: 192.0000 Each(s)
Rivet, Universal Head

Pick:

Qty	Part Number	Description	Batch
25	MS20470AD4-4	Rivet	

Date: Friday, 03/11/2006 7:48:20 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR PANEL

Job Number: 29243

Part Number: D32961

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble hinges as per Dwg D3296

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W. D. 11.20

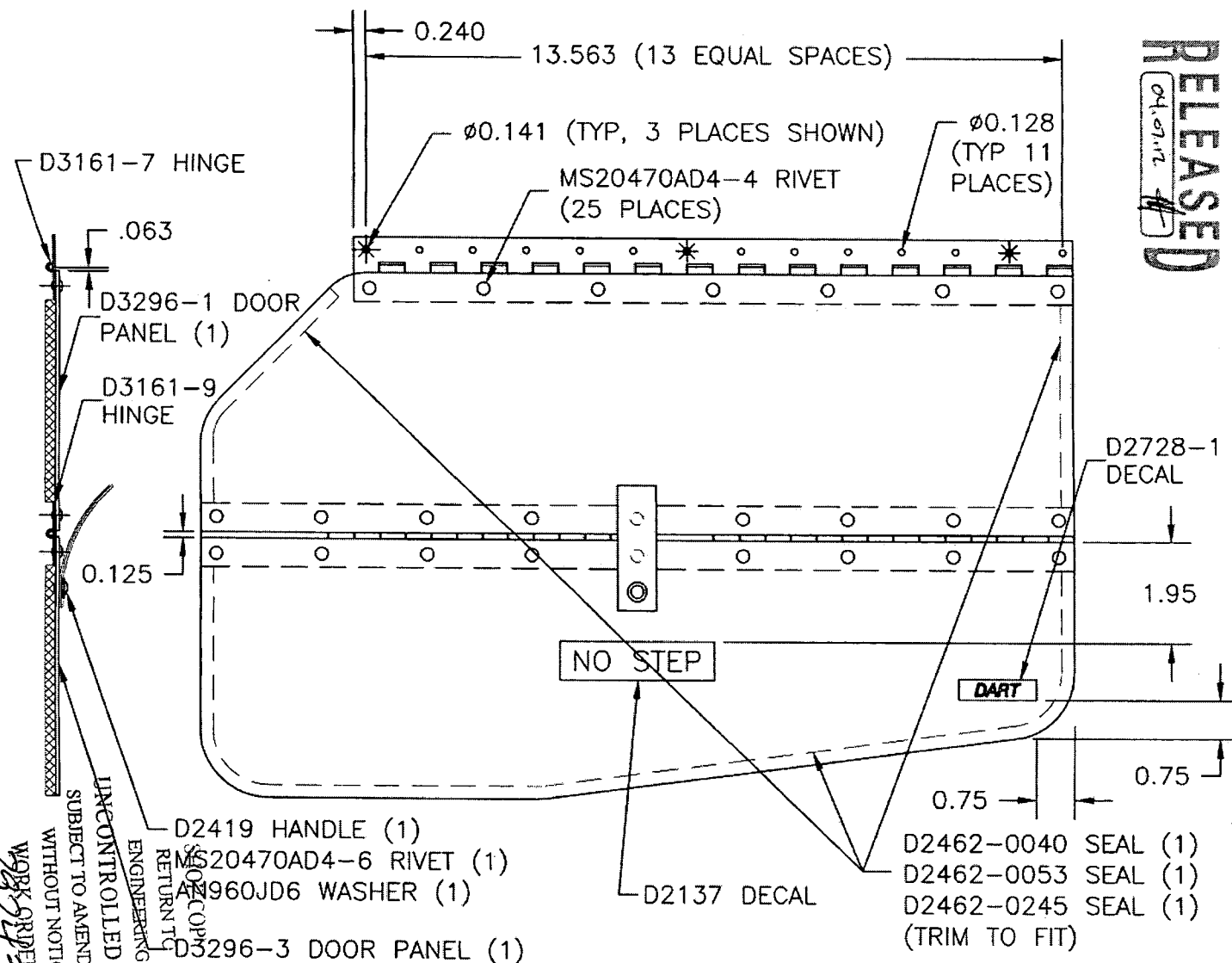
mloef/11/17

2006/11/20



RELEASED
04.07.12

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296
DATE 04.06.28		TITLE DOOR ASSEMBLY
A	04.06.28	NEW ISSUE
		REV. A 1 OF 2 SCALE 1:3

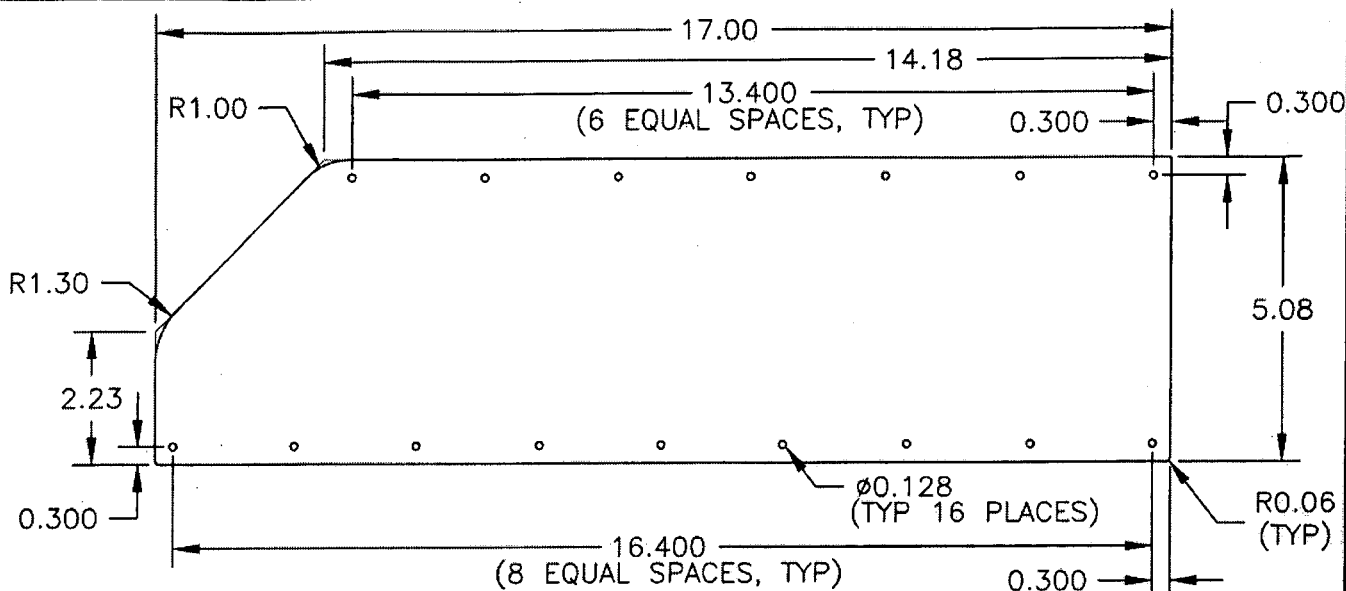


D3296-041 DOOR ASSEMBLY

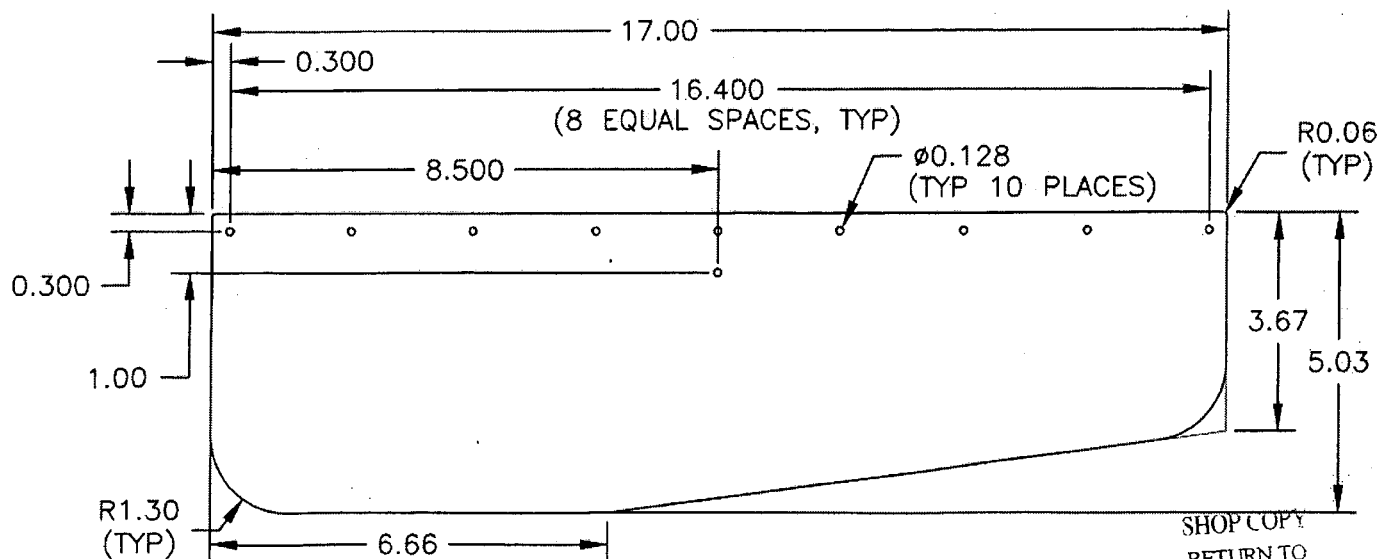
- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
RELEASED
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29243

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.